



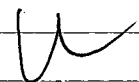


Work Order ID 60978

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PRELIMINARY ISSUE

Item ID: D4154-047 Accept  Setup Start 
 Revision ID: PRELIM Stop 
 Item Name: Wearplate Assembly
 Start Date: 8/03/10 Start Qty: 2.00  Cust Item ID:
 Required Date: 8/05/10 Req'd Qty: 2.00  Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4154	PA1

100 Weld per dwg A/R S.S. rod Batch: M^c 08160 0.00




Large Fab

Memo 0.00

Large Fab

1- After welding transfer drill hole from wearplate to bar as per dwg

EL 10-8-9 

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo 0.00

Quality Control

② AD 10.08.09

115 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo 0.00

Quality Control

inspected to PA1 Dwg
only
Swlos/pd

Test Sit AD 10.08.09

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Item ID:	D4154-047	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Wearplate Assembly					
Start Date:	8/03/10	Start Qty:	2.00		Cust Item ID:	
Required Date:	8/05/10	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M112588.</i> Memo Start Time: <i>1:00</i> Oven Temperature: <i>320°</i> Finish Time: <i>1:30</i>	0.00 0.00							<i>2 BL 10-8-23.</i>
130 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>=> H 10/08/23 x2 M d</i>
140 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							<i>HAC</i>


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Required Date: 8/05/10 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

U 60978-09

POSITIVE RECALL
EFFECTIVE 08-03 AUTH [Signature]
RELEASED _____ DATE _____

Picklist Print

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Work Order ID: 60978

Parent Item: D4154-047

Parent Item Name: Wearplate Assembly







Start Date: 8/03/10

Required Date: 8/05/10

Start Qty: 2.00

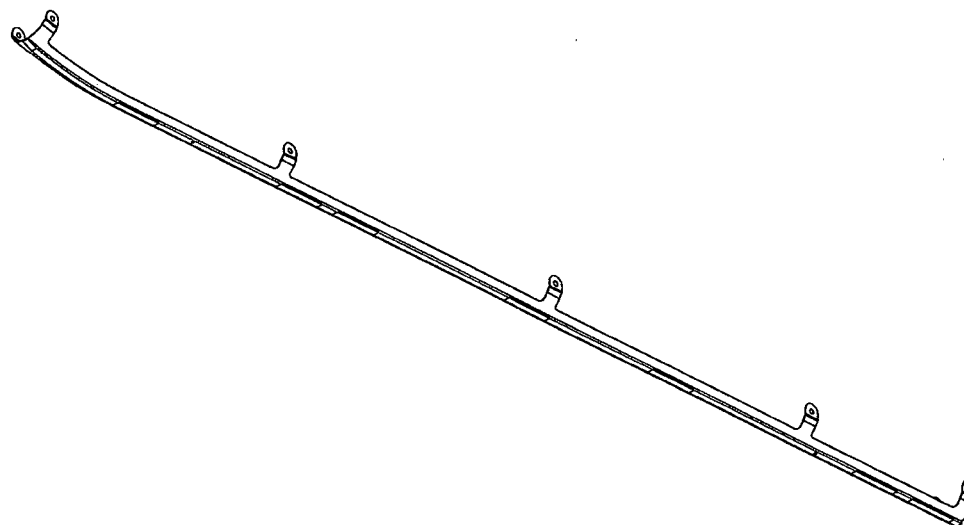
Required Qty: 2.00

Comments: IPP Rev:A 10.08.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1  Plate		Manufactured	No			100	Each	0.0000	1	2			
												EL 10-8-9	
D4155-1  Bar		Manufactured	No			100	Each	0.0000	1	2			
												EL 18-8-9	

60977 x2
60976 x2

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-047	WEARPLATE ASSEMBLY
1	2	D4154-1	PLATE
2	2	D4155-1	BAR
3	A/R	2059B	HARDCOAT

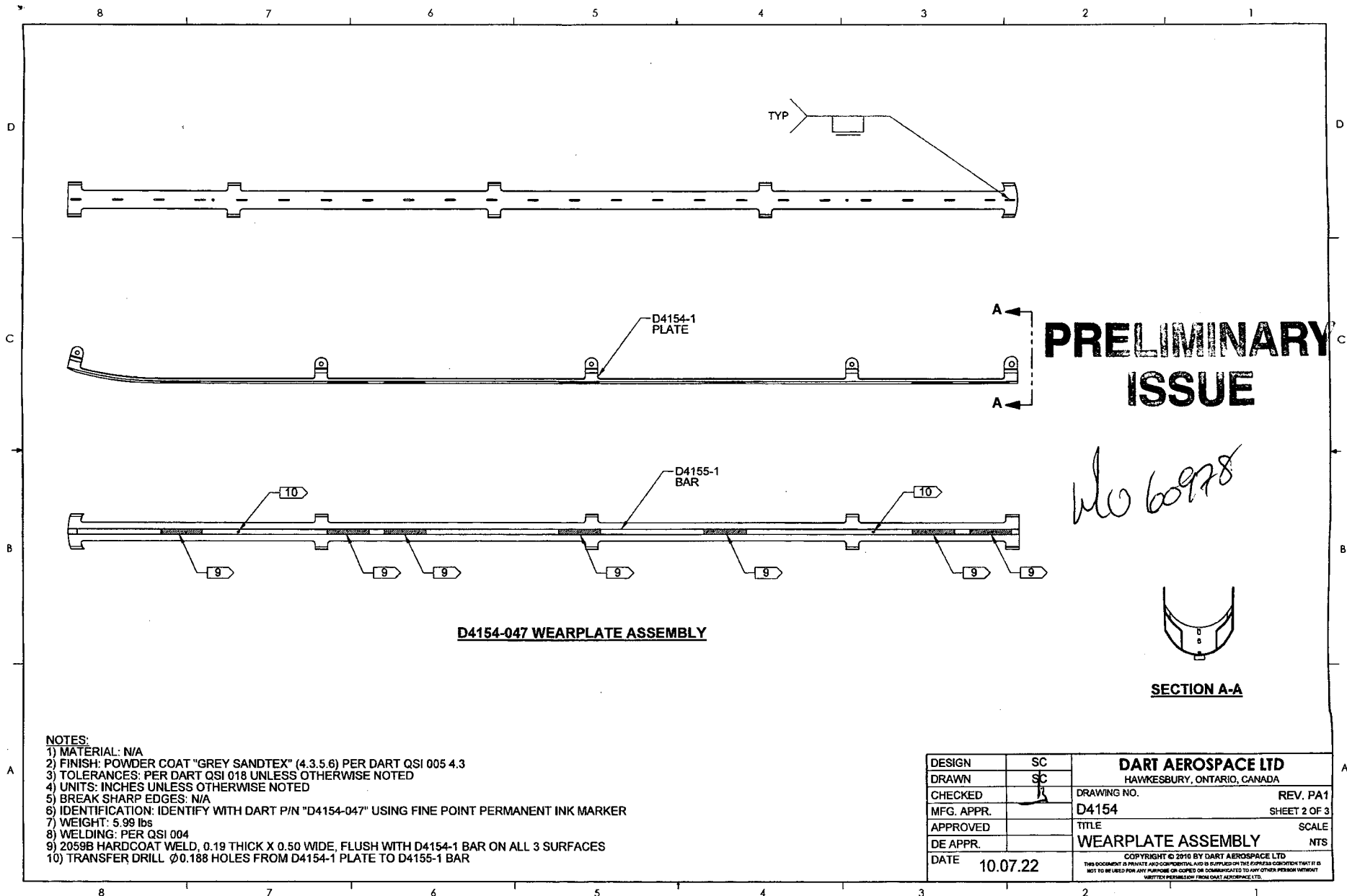


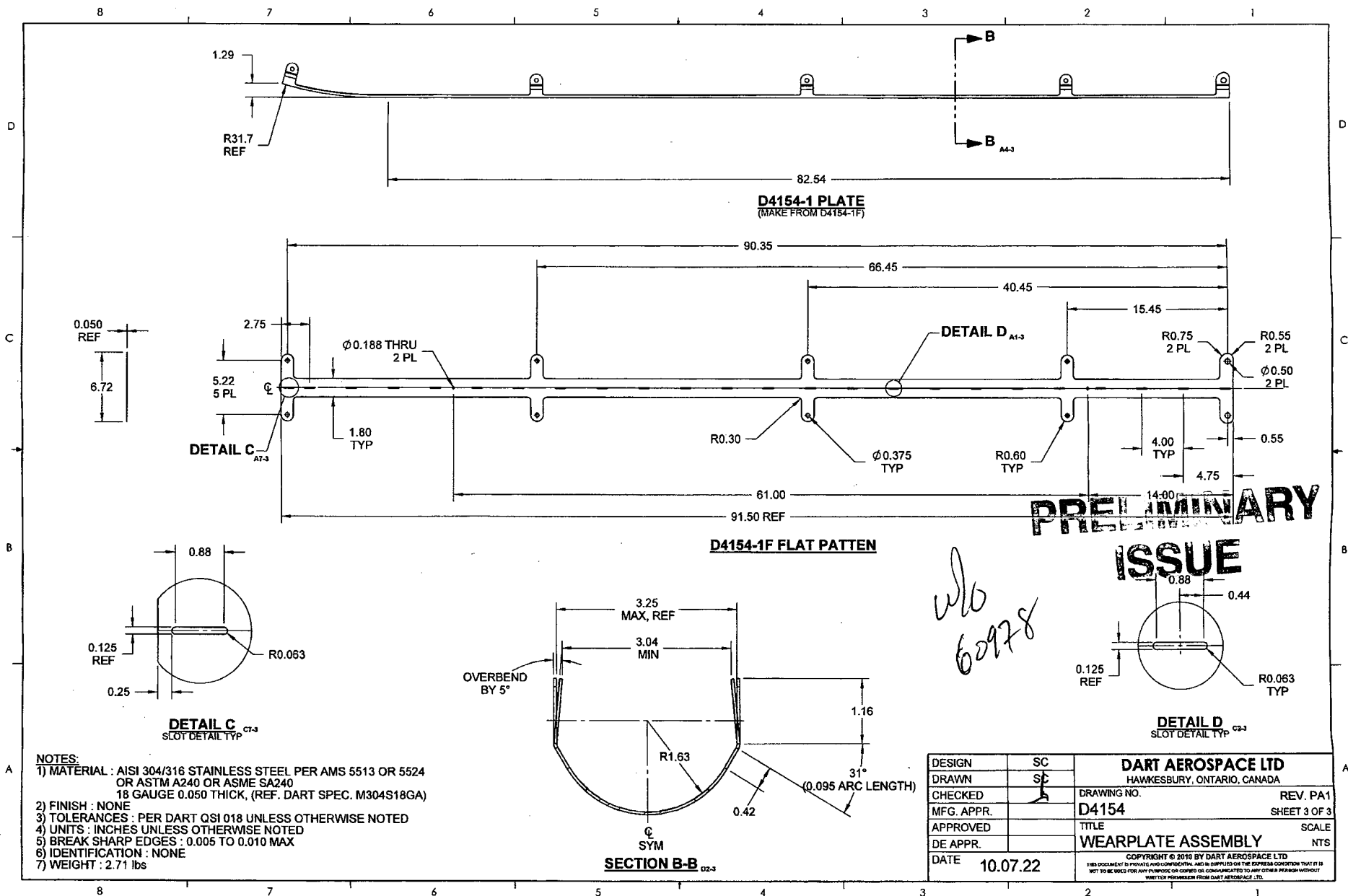
D4154-047 WEARPLATE ASSEMBLY

**PRELIMINARY
ISSUE**

*WLO
60975*


PA1	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION		BY DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4154	REV. PA1 SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE ASSEMBLY	NTS
DE APPR.		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	10.07.22		





NOTES:

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.71 lbs

DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4154	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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